

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2016-06** Date Opened: 06 Jan 16 Title: **Assembly**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350/355** Product Type: **Basket** Product Model: **Medium LH** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
 Additional Work Sheets (Standard Practice)  
 Drawings (See List Below)  
 Parts Distribution Sheet  
 Sub Component Tags  
 Completed Certification  
 Time Sheet (R&D)  
 Notes

Initial or N/A

JC
N/A
JC
JC
JC
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
 Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
76410	3	Basket Assembly	JC
76427	2	Placard	JC
84255	1	Handle Installation	JC
84261	2	Handle Assembly	JC
70405	4	Lid Walkway	JC

**Component Completion**

Quantity Complete on This Work Order  
 Quantity Incomplete on This Work Order  
 Further Processing Required Before Release  
 Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
 Serviceable (Green) Tag Completed  
 In Process (Yellow) Tag Completed  
 Unserviceable (Red) Tag Completed  
 Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
 Non-Conformance Report Required  
 Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
 Research and Development  
 Third Party

Initial or N/A

JC
N/A
N/A

**Traveller**

Install walkway on lid  
 Install lid on basket body  
 Re-tap mounting lug holes and install mount lugs  
 Install handle brackets  
 Install handle  
 Install lid prop  
 Install data plate

Initial or N/A

DB
DB
DB
DB
DB
DB
DB
DB

Work performed by:

Print: D. Bartfai

Sign:

ICC / Dual Inspection performed by:

Print: J. Clarke

Sign:

Work Order closed by:

Print: J. Clarke

Sign:

SCA: AD07

Date: 06-Jan-16

SCA: AD02

Date: 07-Jan-16

SCA: AD02

Date: 07-Jan-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO2016-06</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Med. Cargo Basket</b>	<b>76410-01-02</b>	<b>1</b>	<b>76402-36</b>	<b>New</b>	
12. Remarks <b>Left hand, Modified with walkway on lid and front end cutout IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>07 Jan 2016</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

JAYBIRD HCL

## CARGO BASKET ASSEMBLY - COMMON

2016-06

AS 350 LH MED ASSY

### General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355** – left or right

77610, Revision 1 – Short Basket

→ 76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44** – left or right

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### Options

→ 70405, Revision 3? – Lid Walkway



## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-06

Date Open: 06 JAN 2016

DB

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

DB

### 2. Body Assembly

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – ~~must be completed after hinge installation~~
- Locate 94621-01 Brace over aft cross tube cutout
  - Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation DB

- a. Prepare hinge.
- Cut hinge to length:
    - 776, 906 – 54"
    - 751, 803 – 70"
    - 698, 764, 945 – 72"
    - 784 – 90"
    - 940, 946, 959 – 95"
  - Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
- Locate hinge on basket (standard baskets)
    - centre fore/aft
    - 0.15" – 0.18" up from bottom edge
  - Locate hinge on basket (extra wide baskets)
    - centre fore/aft
    - set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - Remove hinge and de-burr holes in hinge and basket rim.
  - Cleco hinge to basket with 5/32 clecos.
  - Install hinge with CherryMax rivets
    - CR3523-5-02 monel rivets – last 2 rivets in each end
    - CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
- Locate lid on hinge (all baskets)
    - center fore/aft
    - 0.15" – 0.18" down from top edge
  - Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - Remove hinge and de-burr holes in hinge and lid rim.
  - Cleco lid to hinge with 5/32 clecos.
  - Install hinge with CherryMax rivets
    - CR3523-5-02 monel rivets – last 2 rivets in each end
    - CR3213-5-02 aluminum rivets – all other locations



- d. Record PO of hinge and rivets on attached material tracking list.

DB

#### 4. Install Handle

- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
  - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
  - Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
  - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - At first end, remove bolt and repeat step iv.
  - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
  - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

DB

#### 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

AD02

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2016-06Material Tracking Sheet  
Eurocopter AS350 / AS355  
Medium Basket Assembly

1 of 2

Date Opened: 06 JAN 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76410-01- <u>02</u>	<b>Cargo Basket Assembly</b>	(-01 RH, -02 LH) <u>SN 76402-36</u>	
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		<u>2015-36</u>
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	<u>15025</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		76427-01	Placard (right)	0.063 Sheet, 6061-T6 Aluminum	<u>N/A</u>
	. . 1		76427-02	Placard (left)	0.063 Sheet, 6061-T6 Aluminum	<u>11102</u>
	. . 4		CR3213-4-02	Cherry Rivet		<u>15031</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>15056</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>15031</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		76411-01-XX	Basket Body Assembly		<u>2014-32</u>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<u>15075</u>
	. . 8		NAS1149F0663P	Washer		<u>15074</u>
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	<u>15063</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>15031</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>15031</u>
<b>Step 4</b>	. 1		84255-01	Handle Installation		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2015-02</u>
	. . 4		AN3-11A	Bolt		<u>14068</u>
	. . 8		NAS1149F0363P	Washer		<u>14048</u>
	. . 4		MS21044N3	Nut		<u>15086</u>



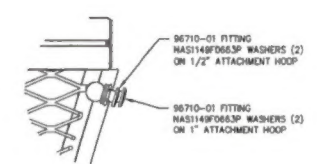
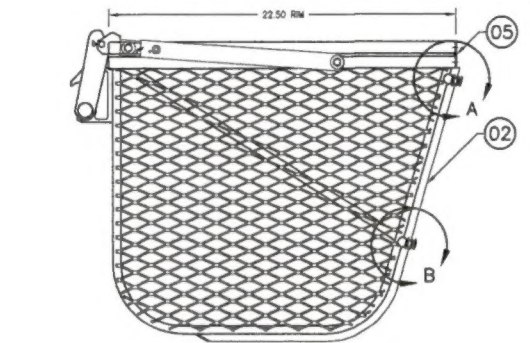
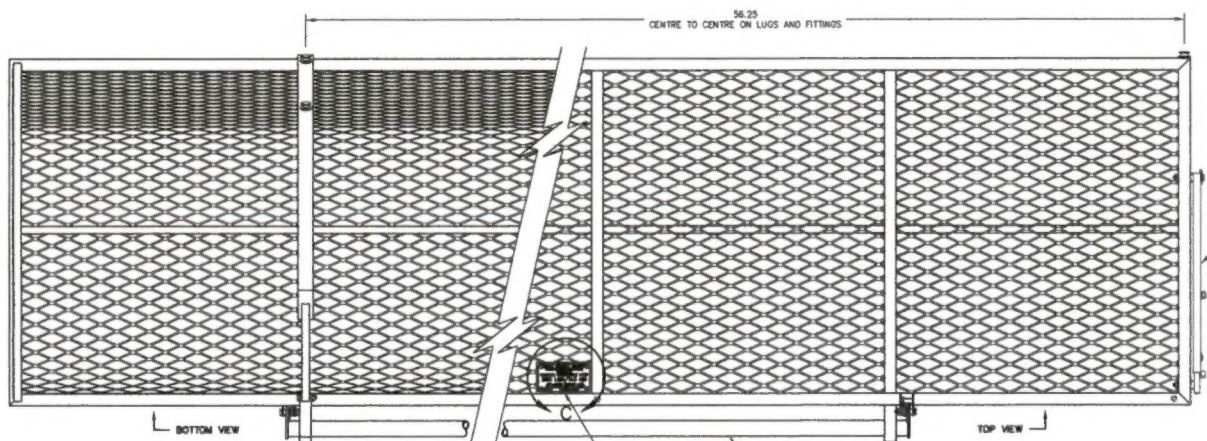
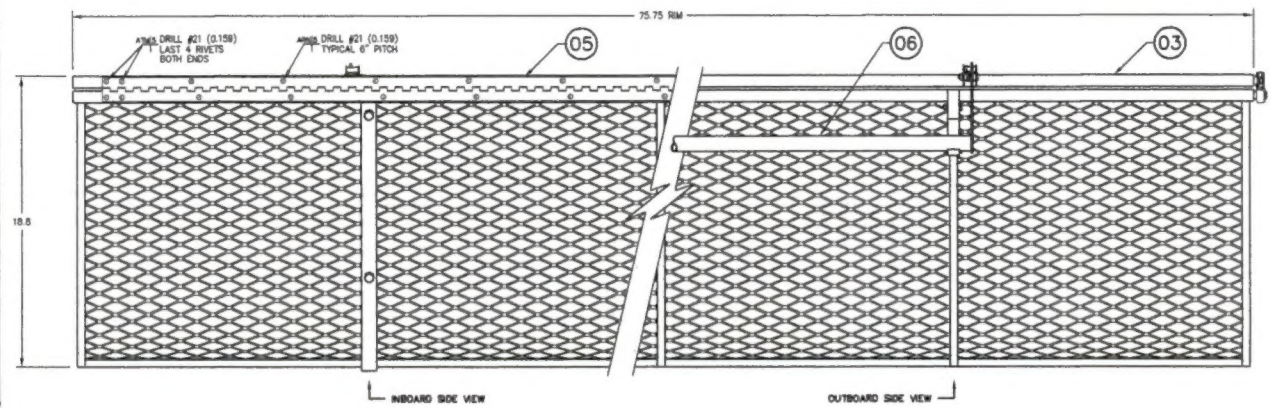
Work Order: 2016-06Material Tracking Sheet  
Eurocopter AS350 / AS355  
Medium Basket Assembly

2 of 2

Date Opened: 06 JAN 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		see attached
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	15071
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	2013-63
	.. 2		AN3-12A	Bolt		13048
	.. 4		NAS1149F0363P	Washer		14048
	.. 2		MS21044N3	Nut		15086
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2016-05
	. 1		AN3-15A	Bolt		14084
	. 1		AN3-17A	Bolt		15031
	. 2		AN970-3	Washer		15014
	. 3		NAS1149F0363P	Washer		15031
	. 2		MS21044N3	Nut		15031
Step 6				Inspection	None	

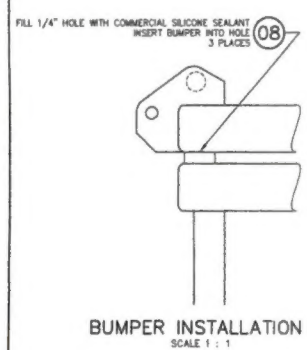
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	14 JAN 08
1	ADDED LH ASSEMBLY	RR	05 MAR 08
2	CHANGED HANDLE CONFIGURATION	BJC	27 JAN 10
3	UPDATE TITLE BLOCK; ADD ALTERNATE RIVETS; HARDWARE P/N'S UPDATED; CHANGE BRACE ASSEMBLY TO INSTALLATION	BJC	10/07/2014



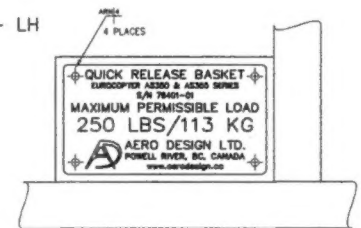
DETAIL A  
SCALE 1 : 2  
TYPICAL FRONT AND REAR

DETAIL B  
SCALE 1 : 2  
TYPICAL FRONT AND REAR

NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



76410-01-01 CARGO BASKET ASSEMBLY - RH  
SHOWN  
76410-01-02 CARGO BASKET ASSEMBLY - LH  
OPPOSITE



DETAIL C  
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

A/R/A/R	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	4	96710-01	FITTING	WASHER			
8	8	CR3523-5-02	CHERRY RIVET	WASHER			
4	4	CR3213-4-02	CHERRY RIVET	WASHER			
3	3	49205-14	08 BUMPER	ARGUS INDUSTRIES			
1	1	78427-02	07 PLACARD				
1	1	78427-01	07 PLACARD				
1	1	84235-01	05 HANDLE BAR INSTALLATION				
1	1	MS20001P4	05 PLANO HINGE				72.0 LONG
1	1	84240-01	04 LID BRACE INSTALLATION				
1	1	69812-01	03 BASKET LID ASSEMBLY				
1	1	78411-01-02	02 BASKET BODY ASSEMBLY (LH)				
1	1	78411-01-01	02 BASKET BODY ASSEMBLY (RH)				
1	1	78410-01-02	01-02 CARGO BASKET ASSEMBLY - LH				
1	1	78410-01-01	01-01 CARGO BASKET ASSEMBLY - RH				

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF. NAS 323	N=MFD. HEAD NEAR SIDE	DR: R. RATHWELL	14 JAN 08
C=COUNTERSUNK	F=MFD. HEAD FAR SIDE	CHECKED: E. BURGOIN	
D=DMPL	DASH NO. FOR LENGTH		
DIGIT=# OF SHEETS			
TO BE DMPLD			
BASIC CODES:			
BJ=MS20470AD	+ INSTALL NEW RIVET		
BB=MS20426AD	+ REMOVE/REPLACE RIVET		
ABN=CR3213	- EXISTING RIVET		
ATM=CR3523			

EUROCOPTER AS350 & AS355 SERIES	QUICK RELEASE CARGO BASKET	CARGO BASKET ASSEMBLY (MEDIUM)
0688A MALASPINA ROAD	POWELL RIVER, BC, CANADA, V8A 0G3	TEL: 804-463-8378
SCALE 1 : 4	DWG. SIZE	DWG. NO.
SHEET 1 OF 1	A1	76410
		3



## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-06

Complete  
(initial or SCA #)

Date Open: 06 JAN 2016

Prev. clw

1. Weld Lever Assembly – handle lever jig required
  - a. Set MS20615-4M3 monel rivet into socket in jig
  - b. Set 36274-01 bushing into socket in jig
  - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
  - d. TIG weld around bushing using ER308L rod.
  - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
  - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
  - g. Record material POs on attached material list.

DB

2. Clean up
  - a. Clean lever assembly by media blasting with glass bead.
  - b. Drill out lever bushing to O (0.316) on lathe:
    - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
    - ii. Run at 300 RPM.
    - iii. Apply a drop of Rapid-Tap to drill.
  - c. De-burr.

3. Fabricate Handle Assembly
  - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
  - b. Measure across TOP side of levers.
  - c. Cut handle tubing to length measured.
    - i. Handles under 40" long: 1.0" x 0.035 round tube
    - ii. Handles over 40" long: 1.0" x 0.065 round tube
  - d. De-burr tube.
  - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
  - f. Record material PO on attached material list.

DB

4. Weld Handle Assembly
  - a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD-05

5. Clean up
  - a. Clean welded area with scotch-brite.

DB

6. Final Inspection –

To be completed by a different person than the previous steps.

  - a. Welds for complete and handle for fit.
  - b. Tag complete and inspected parts in preparation for installation.

\_\_\_\_\_



Work Order: 2016-06Material Tracking Sheet  
AS350 / AS355 Medium Basket Handle Assembly

1 of 1

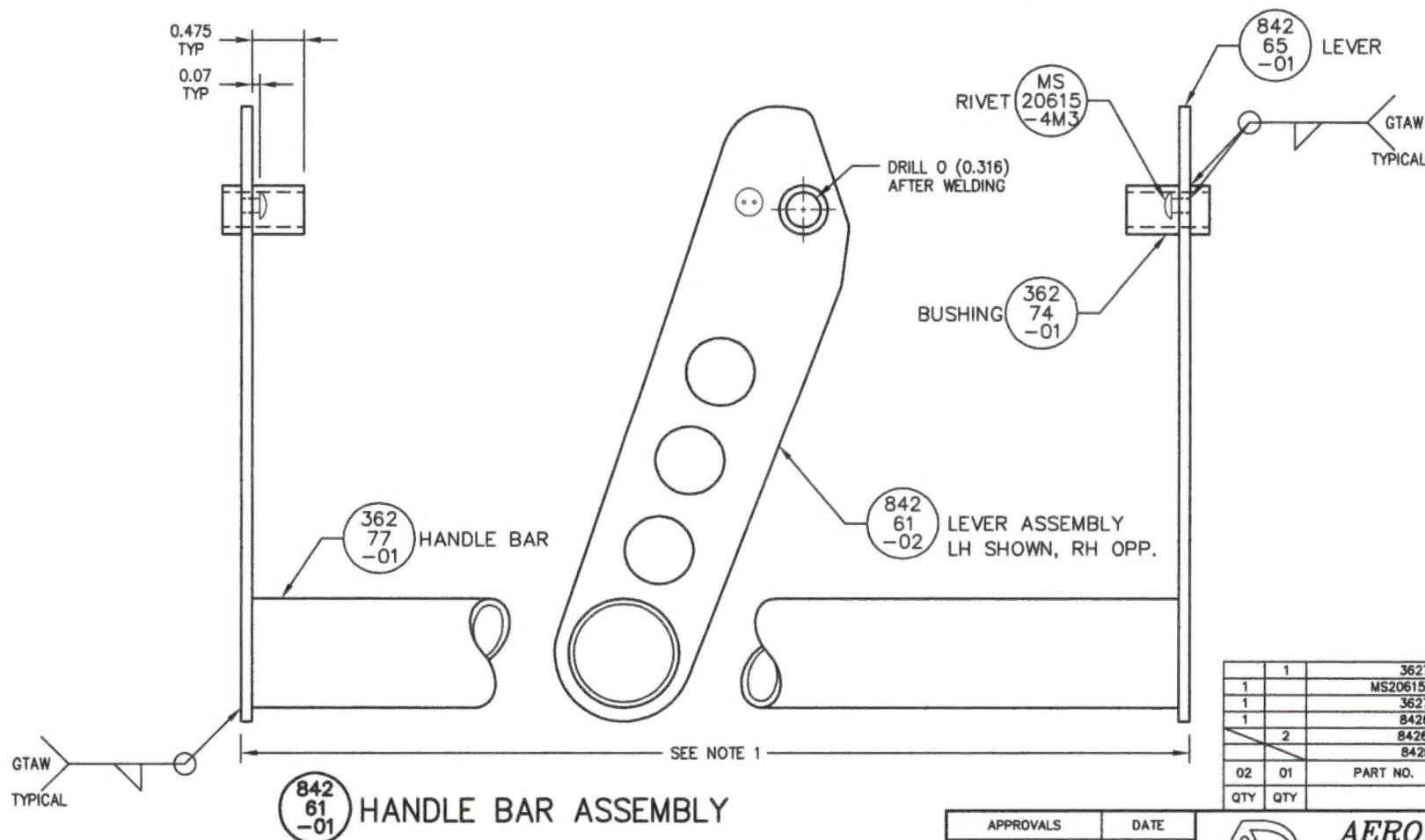
Date Opened: 06 JAN 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	84261	<b>84261-01</b>	<b>Handle Assembly</b>		
<b>Step 1</b>				<i>Weld Lever Assembly</i>		<i>2015-122</i>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R		--	Welding Rod	ER308L TIG Rod	
<b>Step 2</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.035 Rnd. Tube	<i>15073</i>
<b>Step 4</b>				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
<b>Step 5</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection - Final Assembly</i>	<i>None</i>	

2016-06

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



## NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



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TEL: 604.489.8876 www.aerodesign.ca

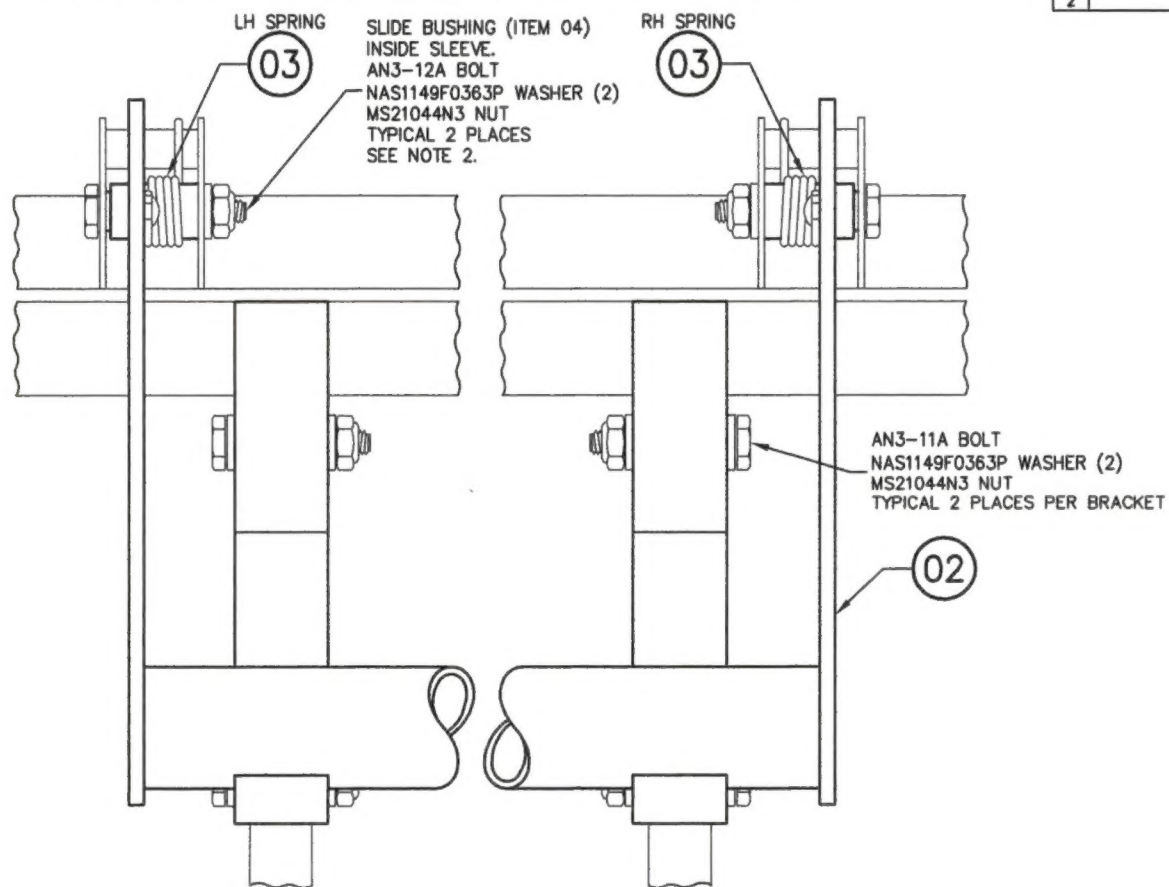
**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84261	2

2016-06

## NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

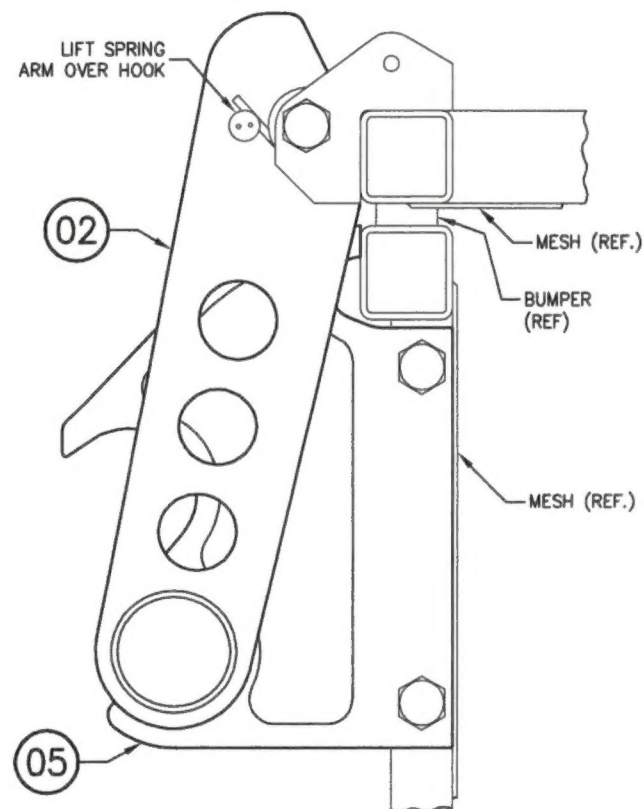


## (01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX  $\pm 0.010$   $\pm 1/2^\circ$   
X.XX  $\pm 0.03$   
X.X  $\pm 0.1$



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HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2



2016-06

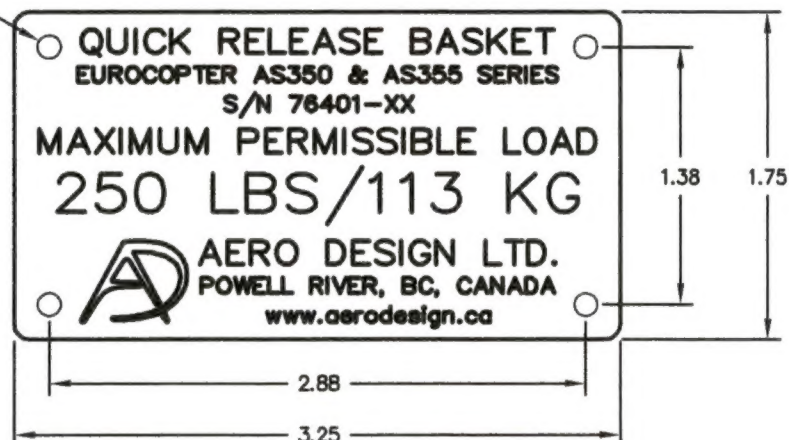
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG, ADD LEFT PLACARD (02)	BJC	JAN 27/10
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

## NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
 "S/N 76401-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "250 LBS/113 KG" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH  
 "www.aerodesign.ca" - 0.080 HIGH

2. ON 76427-02: S/N IS 76402-XX.


DRILL #30 (0.129)  
4 PLACES



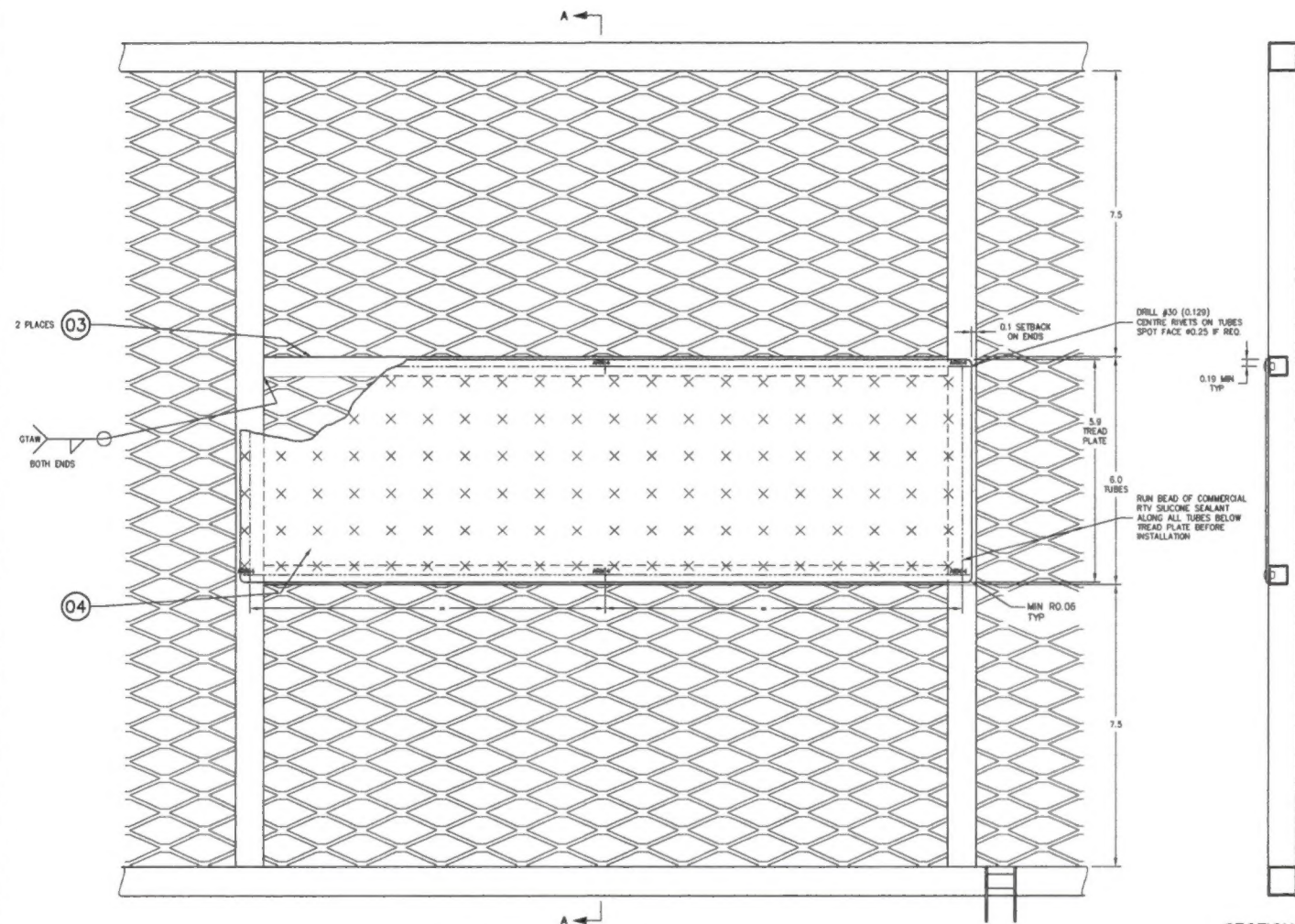
01 PLACARD

02 PLACARD

76427-02	02	PLACARD (LH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
76427-01	01	PLACARD (RH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS					

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX ±0.010                      ±1/2° X.XX ±0.03 X.X ±0.1					<b>EUROCOPTER AS350 &amp; AS355 SERIES</b> <b>QUICK RELEASE CARGO BASKET</b> <b>PLACARD</b>	
	SCALE 1 : 1		DWG. SIZE <b>A4</b>	DWG. NO. <b>76427</b>		REV. <b>2</b>	
	SHEET 1 OF 1						

2016-06



(01) BASKET LID ASSEMBLY

SECTION A-A

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS330 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS330 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/03/2014

## NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02		BLIND RIVET	ALTERNATE: HR3213-4-02		
1	70405-04	04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03	TUBE	4130 STEEL COND. N	MIL-T-8738	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1		02	BASKET LID ASSEMBLY		
	70405-01	01	BASKET LID ASSEMBLY - MODIFIED WITH STEP			
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF. NAS 523 C=COUNTERSUNK D=DIMPLE DIGIT # OF SHEETS TO BE DIMPLED BASIC CODES: BJ = MS20470AD BB = MS20426AD ARN = CR3213 ARN = CR3212	DASH NO. FOR DIAMETER H=HFD. HEAD NEAR SIDE F=HFD. HEAD FAR SIDE DASH NO. FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E. BURCOON	DATE 21 SEPT 2008	<b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.3376 www.aerodesign.ca
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		
SCALE 1 : 1.5 SHEET 1 OF 1				DWS. SIZE A1 70405 4

CARGO BASKET  
LID STEP MODIFICATION